

Date: Monday, 11/05/2009 1:22:23 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GHW MOD KIT
Job Number : 47861	
Estimate Number : 11182	
P.O. Number :	Part Number : D350615041
This Issue : 11/05/2009 S.O. No. :	Drawing Number : D350-615
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 47406	Material :
Written By :	Due Date : 10/06/2009 Qty: 60 Um: Each
Checked & Approved By : <u>JUD 09.05.11</u>	
Comment : Est Rev:K Removed Manufacturing 05-12-05 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Handwritten: JUD 09/05/29

**Comment:** DOCUMENT CONTROL

Photocopy bluefile and type labels (2 GHW Kits per box) as per PPP D350-615-041 CHG003

Handwritten: 09/05/29

2.0	D30153	Locknut
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**Comment:** Qty.: 3.0000 Each(s)/Unit Total : 150.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 D3015-3 5/16 Locknut

Handwritten: B 45384

Handwritten: B 48111

Handwritten: 11x

Handwritten: 09/05/28

3.0	D30155	SS Nylock Nut 7/16
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3015-5 7/16 Locknut

Handwritten: B 45393

Handwritten: B 41899

Handwritten: 25x

Handwritten: 09/05/28

4.0	51618015C	SS Bolt 5/16-18 1.5" L
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**Comment:** Qty.: 3.0000 Each(s)/Unit Total : 150.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 5/16-18-015C 5/16 Bolt 1.5 Long

Handwritten: M 111580

Handwritten: 09/05/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: GHW MOD KIT

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	516WC	SS Flat Washer 5/16
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 600.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
12	5/16WC	5/16 Flat Washer	

M110726

EP 09/05/28

6.0	71614050C	SS Bolt 7/16 5" Long
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	7/16-14-050C	7/16 Bolt 5.0 Long	

M110729

EP 09/05/28

7.0	716WC	SS Flat Washer 7/16
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	7/16wc	7/16 Washer	

M110458

1	D2282-041(Ref)	"T" Handle Assembly	
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B47406A

1	D2282-043 (Ref)	Saddle Assembly	
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B47406B

EP 09/05/28

8.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D2282-041 with D2282-043 as per Dwg D350-615 Only engage one thread on three 5/16-18-015C bolts

EP 09/05/28 (60)

9.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

8/09/05/28 counter (460)

10.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

8/09/05/28 +38 sets

11.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-615-041

Location:

PPP Rev:

E

9/5/29

60

SV

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: GHW MOD KIT

Job Number: 47861

Part Number: D350615041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/04 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-06-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>BW</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>MAY</i>	APPROVED <i>BW</i>	DRAWING NO. D350-615	REV. B SHEET 1 OF 2
DATE 97.10.21		TITLE GROUND HANDLING WHEEL MOD.	SCALE NTS
A	95.03.23	NEW ISSUE	
B	97.10.21	CHANGE NUMBERING SCHEME	

-041	Part No.	Description
X	D350-615-041	Ground Handling Wheel Mod.
1	D2282-041	"T" ASSEMBLY
1	D2282-043	SADDLE ASSEMBLY
3	5/16-18-015C	5/16 BOLT 1.5 LONG
3	5/16-18NC	5/16 LOCKNUT (D3015-3)
12	5/16WC	5/16 WASHER
1	7/16-14-050C	7/16 BOLT 5.0 LONG
1	7/16-14NC	7/16 LOCKNUT (D3015-5)
2	7/16WC	7/16 WASHER

THESE INSTRUCTIONS ARE TO BE USED IN CONJUNCTION WITH
THE AIRCRAFT MAINTENANCE AND OVERHAUL INSTRUCTION MANUAL
AC43.13.1A & 2A ACCEPTABLE METHODS, TECHNIQUES, AND PRACTICES

INSTALLATION:

1. Remove existing ground handling wheel pump saddle.
2. Replace saddle with D350-615-041.
3. Torque 5/16 bolts to bottom, then back-off half turn to allow easy rotation without excessive play.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 47861



DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED DWB	APPROVED BW	DRAWING NO. D350-615	REV. 8 SHEET 2 OF 2
DATE 97.10.21		TITLE GROUND HANDLING WHEEL MOD.	SCALE NTS

